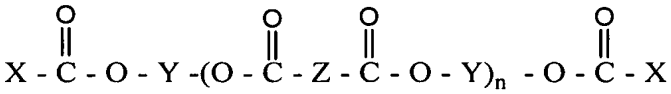
Amendments to the Claims:

The following claims will replace all prior versions of the claims in this application (in the unlikely event that no claims follow herein, the previously pending claims will remain):

1-18. (Cancelled).

19. (Currently Amended) A composition comprising:
a metal working fluid comprising an ester represented by the following:



wherein
X is ~~an~~ a saturated and linear aliphatic hydrocarbyl group having ~~5-11~~ 7-11 carbon atoms;
Y is an alkylene group having 4-6 carbon atoms;
Z is an a saturated linear aliphatic hydrocarbyl group having 4 carbon atoms and
n is a weight average number between 1.5 and 10.

20. (Cancelled).

21. (Previously Presented) The composition of claim 19 wherein the metal working fluid further comprises an oil selected from a mineral oil, a vegetable oil, or an animal oil.

22. (Previously Presented) The composition of claim 19 wherein the metal working fluid further comprises a surfactant.

23. (Previously Presented) The composition of claim 19 wherein the metal working fluid further comprises an emulsifier.

24. (Previously Presented) The composition of claim 19 wherein the metal working fluid further comprises a corrosion inhibitor.

25. (Previously Presented) The composition of claim 19 wherein the metal working fluid further comprises water.

26. (Previously Presented) The composition of claim 19 wherein the metal working fluid further comprises a metal deactivator.

27. (Previously Presented) The composition of claim 19 wherein the metal working fluid further comprises an anti-foam agent.

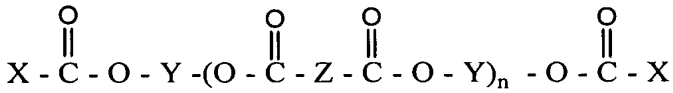
28. (Previously Presented) The composition of claim 19 wherein the metal working fluid further comprises an anti-oxidant.

29. (Previously Presented) The composition of claim 19 wherein the metal working fluid has a kinematic viscosity at 100°C less than $20mm^2/s$ and a kinematic viscosity at 40°C of less than $150mm^2/s$.

30. (Previously Presented) The composition of claim 19, wherein n is a weight average number between 1.5 and 5.

31. (Previously Presented) The composition of claim 19, wherein X is a saturated and linear aliphatic hydrocarbyl group having 7-9 carbon atoms, and wherein Y is a saturated and branched alkylene group having 4-6 carbon atoms.

32. (Currently Amended) A composition comprising:
a metal working fluid comprising an ester represented by the following:



wherein

X is ~~an~~ a saturated and linear aliphatic hydrocarbyl group having ~~5-11~~ 7-11 carbon atoms;

Y is an alkylene group having 4-6 carbon atoms;

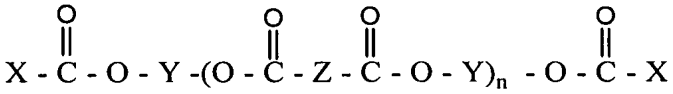
Z is an a saturated linear aliphatic hydrocarbyl group having 4 carbon atoms and

n is a weight average number between 1.5 and 10; and

wherein the ester has a kinematic viscosity less than 150 cst at 40°C.

33. (New) A composition comprising:

a metal working fluid comprising from 5 to 70% by weight calculated on the weight of the metal working fluid of an ester represented by the following:



wherein

X is a saturated and linear aliphatic hydrocarbyl group having 7-11 carbon atoms;

Y is an alkylene group having 4-6 carbon atoms;

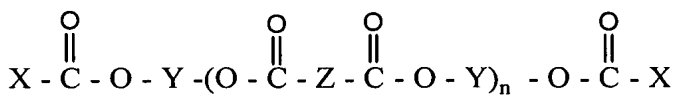
Z is an a saturated linear aliphatic hydrocarbyl group having 4 carbon atoms and

n is a weight average number between 1.5 and 10; and

a component selected from the group consisting of mineral oils, oils of vegetable, oils of animal, and other synthetic esters.

34. (New) A composition comprising:

a metal working fluid comprising an ester represented by the following:



wherein

X is a saturated and linear aliphatic hydrocarbyl group having 7-11 carbon atoms;

Y is an alkylene group having 4-6 carbon atoms;

Z is an a saturated linear aliphatic hydrocarbyl group having 4 carbon atoms and

n is a weight average number between 1.5 and 10; and

water.

35. (New) The composition of claim 34, wherein the water is present in the composition in a ratio to metal working fluid between 99:1 and 1:99.

36. (New) The composition of claim 34, wherein the water is present in the composition in a ratio to metal working fluid between 20:80 to 2:98.